

Work Order ID 86410

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Item ID: D4417-011 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Q.R. Step Assembly (206L/407)
 Start Date: 6/28/12 Start Qty: 2.00 *2* Cust Item ID:
 Required Date: 6/28/12 Req'd Qty: 2.00 *2* Customer:

Reference:

Approvals: Process Plan: Date: Tooling: Date: Run Start *NR1*
 QC: Date: SPC (Y/N): Date: Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D2690	B2
D4417	B

100 Pick Kit 0.00

100

Packaging

Packaging

Memo

0.00

120

0.00

120

HandFinish

Hand Finishing

Memo

0.00

1- ASSEMBLE AS PER DWG
 2- USE CBL-1240 AND CBL-460 TO MAKE D2690-6. CUT CBL-1240
 CABLE AND CRIMP CBL-460 AS PER DWG D2690

12/6/28

2 φ BL 127-25

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QC: Date: SPC (Y/N): Date: Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 *130* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00	DAS 16 6-23	12/26/12					
210 *210* Packaging Packaging	Identify as per dwg & Stock Location: <u>D4417-011</u> Memo	0.00	5/4255. MPP 89639			2	0	12/12-7.25. 12/8/30	
220 *220* QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00						12/19/5 MFC 12-08-30	

Picklist Print

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Work Order ID: 86410

Parent Item: D4417-011

Parent Item Name: Q.R. Step Assembly (206L/407)

Start Date: 6/28/12

Required Date: 6/28/12

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP REV:A NEW ISSUE 11-07-11 JLM VERIFIED BY:EC IPP REV:B 11.08.17 PER
REVB. DD VERF:JLM IPP REV:C 11.10.25 replace D2690-6 for CBL-460 & CBL-
1240 for assembling purpose DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
CBL-1240 Cable		Purchased	No			120	f	807.1985	0.708	1.416		BL 12-7-25.	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				GA		807.198501							
				113565		3.911789							
				119021 ✓		290.253312			40"				
				119690		13.0334							
				122190		500							
CBL-460 Loop Sleeve		Purchased	No			120	Each	632.0000	2	4		BL 12-7-25.	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				GA		632							
				121574 ✓		632			4.				
D4417-041 Step Assembly		Manufactured	No			120	Each	0.0000	1	2		BL 12-7-25.	
D4418-1 Step Lug		Manufactured	No			120	Each	4.0000	2	4			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST110 86414.		4			4.				
				73193		2							
				84052		2							

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Work Order ID: 86410

Parent Item: D4417-011

Parent Item Name: Q.R. Step Assembly (206L/407)

Start Date: 6/28/12

Required Date: 6/28/12

Start Qty: 2.00

Required Qty: 2.00

D2570 Manufactured No 120 Each 851.0000 4 *SP* 8

Bushing

Location	Loc Qty	Loc Code
ST011	851	
72960	41	
78586	9	
79493	12	
81956	24	
81957	130	
82874	35	
85411	400	
85412	200	

AN4C16A Purchased No 120 Each 34.0000 2 *SP* 4

BOLT

Location	Loc Qty	Loc Code
ST358	34	
117441	14	
121259	10	
121649	10	

AN4C36A Purchased No 120 Each 40.0000 2 *SP* 4

Bolt

Location	Loc Qty	Loc Code
ST360	40	
118518	40	

MS17984-C415 Purchased No 120 Each 1.0000 2 *SP* 4

Pin, Quick Release

Location	Loc Qty	Loc Code
ST315 <i>122389</i>	1	
<i>122389</i>	1	

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Work Order ID: 86410

Parent Item: D4417-011

Parent Item Name: Q.R. Step Assembly (206L/407)

Start Date: 6/28/12

Required Date: 6/28/12

Start Qty: 2.00

Required Qty: 2.00

MS21043-4 Purchased No 120 Each 2,003.0000 4 8

Nut

Location	Loc Qty	Loc Code
FG	40	
104603	40	
ST301	963	
119546	73	
121162	390	8
121652	500	
ST318	1000	
122141	1000	

D4428-1
Bushing ✓

Manufactured No

120 Each 4.0000 2 4

Location	Loc Qty	Loc Code
ST139F	4	2
72555	2	
73195 ✓	2	2.

NAS1149C0432R
Washer

Purchased No

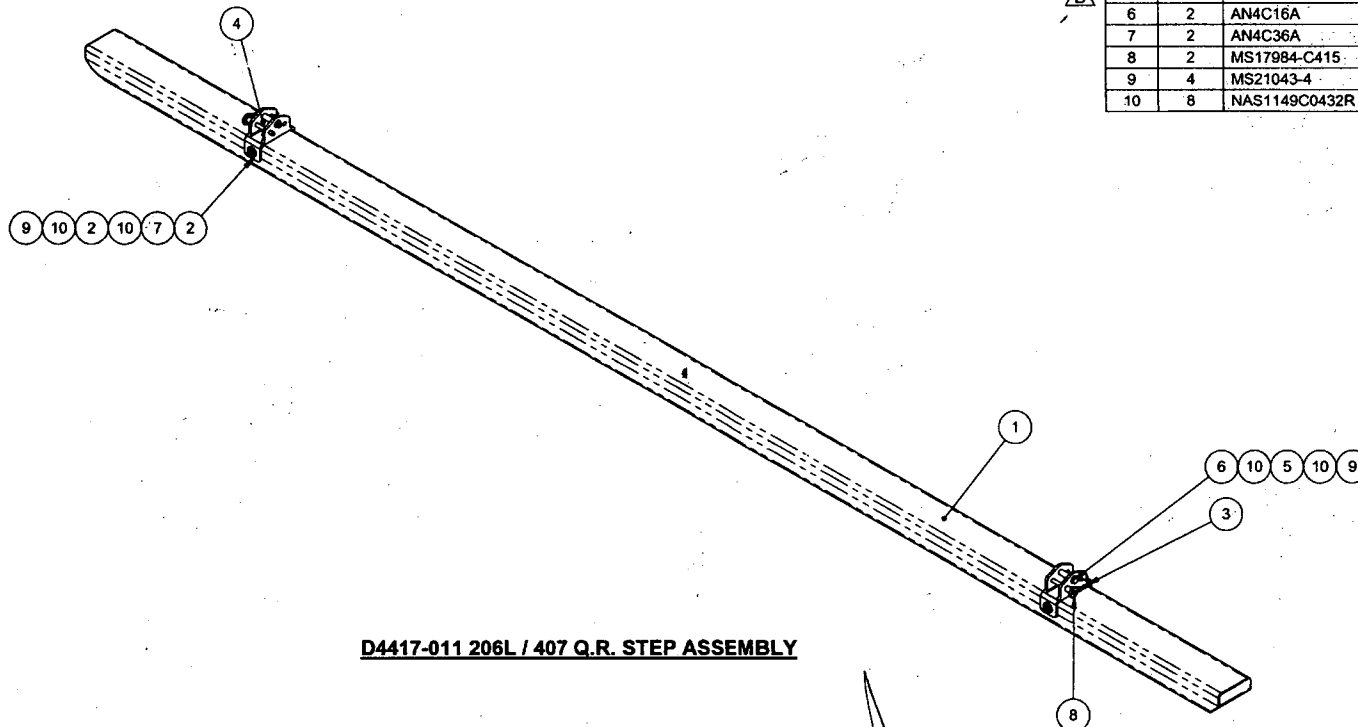
120 Each 3,628.0000 8 16

Location	Loc Qty	Loc Code
ST297	1070	
117291	70	
119124	1000	
ST298	2558	
121255	2558	16

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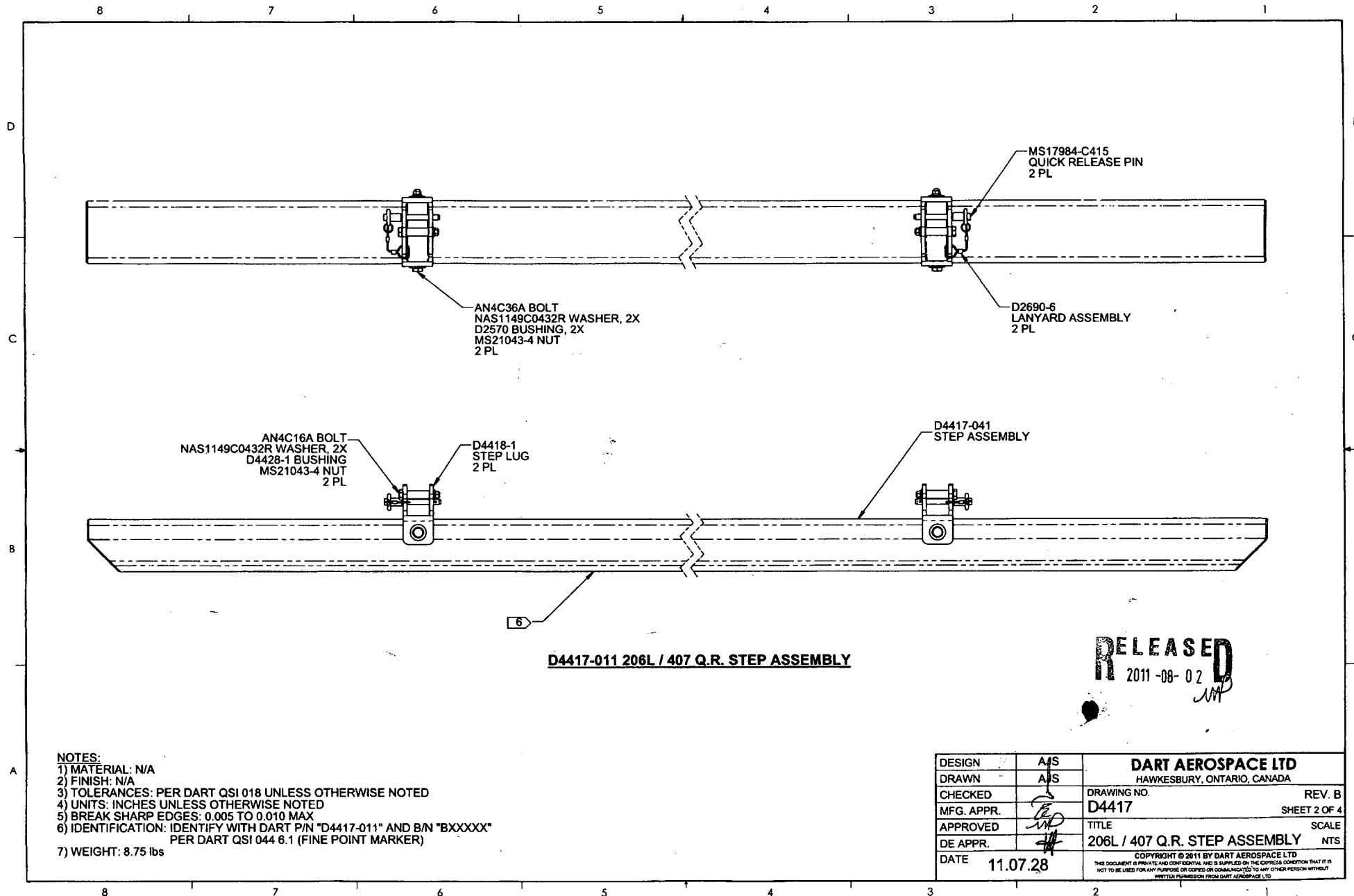
D4417-011 206L / 407 Q.R. STEP ASSEMBLY

W/8644

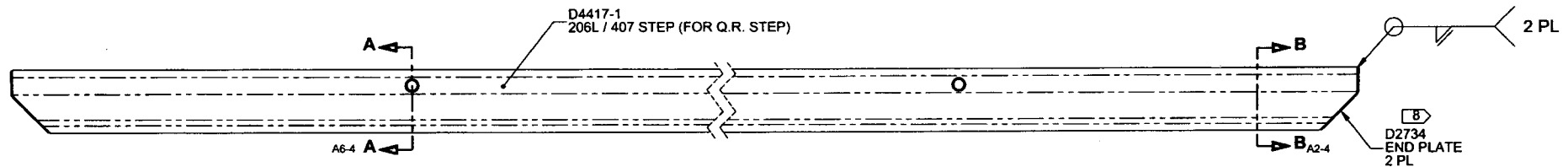
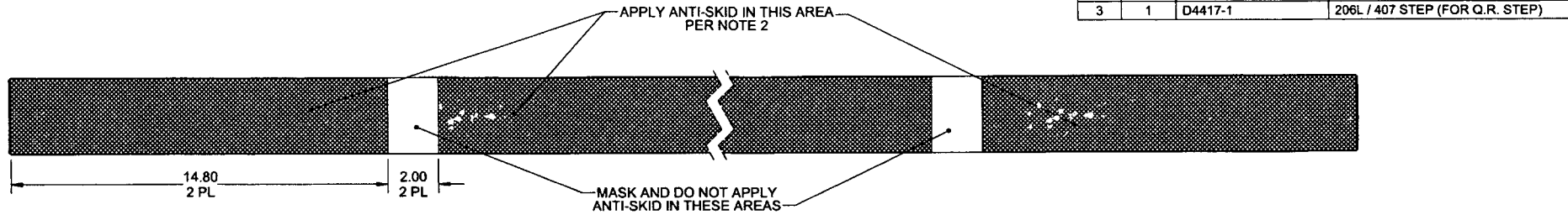
ITEM	QTY	P/N	DESCRIPTION
	X	D4417-011	206L / 407 Q.R. STEP ASSEMBLY
1	1	D4417-041	STEP ASSEMBLY
2	4	D2570	BUSHING
3	2	D2690-6	LANYARD ASSEMBLY
4	2	D4418-1	STEP LUG
5	2	D4428-1	BUSHING
6	2	AN4C16A	BOLT
7	2	AN4C36A	BOLT
8	2	MS17984-C415	QUICK RELEASE PIN (BLBS-020)
9	4	MS21043-4	NUT
10	8	NAS1149C0432R	WASHER

RELEASED
2011-08-02

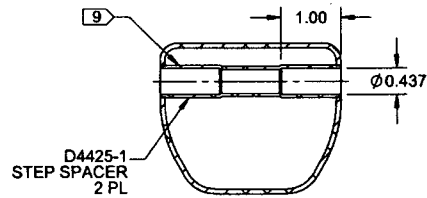
B	REPLACED NAS43DD4-64 SPACER WITH ITEM 5. ITEM 3 WAS -S.	AJS	11.07.28
A	NEW ISSUE	AJS	11.07.04
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D4417 REV. B SHEET 1 OF 4 TITLE 206L / 407 Q.R. STEP ASSEMBLY NTS SCALE DATE 11.07.28	
DRAWN	AJS		
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.		COPYRIGHT © 2011 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL. IT IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	



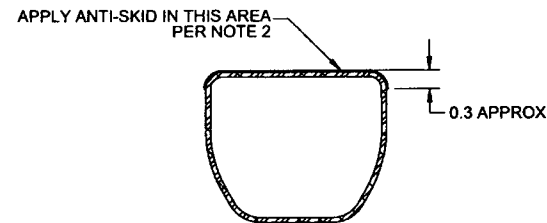
ITEM	QTY -041	P/N	DESCRIPTION
	X	D4417-041	STEP ASSEMBLY
1	2	D2734	END PLATE
2	2	D4425-1	STEP SPACER
3	1	D4417-1	206L / 407 STEP (FOR Q.R. STEP)



D4417-041 STEP ASSEMBLY



**SECTION A-A C7-4
SCALE 2X**



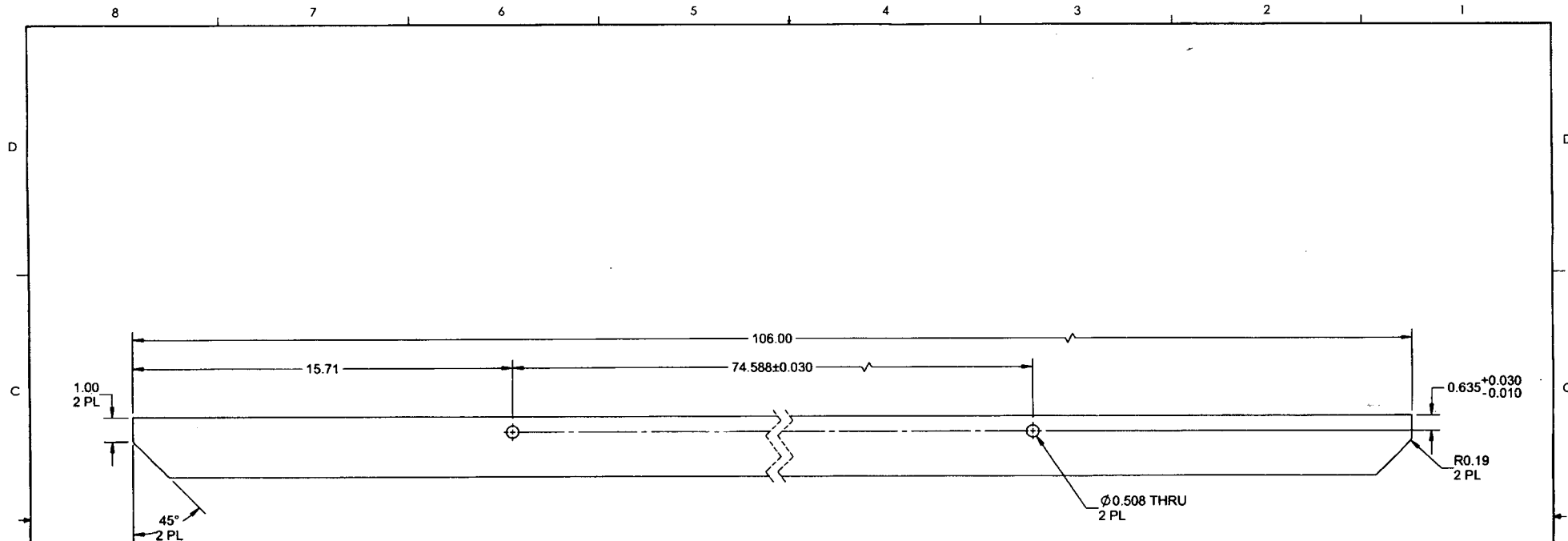
**SECTION B-B C2-4
SCALE 2X**

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
APPLY BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 8.00 lbs
- 8) APPLY ALODINE AFTER WELDING ON THE D2734 END CAPS AND PRIOR TO INSTALLATION OF D4425-1 STEP SPACERS.
- 9) SWAGE TO Ø0.437 X 1.00 DEEP PER QSI 002

DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED		DRAWING NO. D4417	REV. B SHEET 3 OF 4
MFG. APPR.		TITLE 206L / 407 Q.R. STEP ASSEMBLY	SCALE NTS
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DATE	11.07.28		

RELEASED
2011-08-02



D4417-1 206L / 407 STEP (FOR Q.R. STEP)

RELEASED
2011-08-02

NOTES:

- 1) MATERIAL: MAKE FROM D2622 EXTRUSION
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 7.77 lbs

DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D4417	SHEET 4 OF 4
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DE APPR.		206L / 407 Q.R. STEP ASSEMBLY	NTS
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